

54424 Draw

Work Order ID 52797



Page 1

October 14, 2009 10:46:31 AM

Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: BSDate: 09-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: ____ & Dwg D3391 Rev: ____

a.m 09-10-28 ①

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

a.m 09-10-28 ①

111

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

3) 80810/29

① /

Work Order ID 52797

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Page 2

Item ID: D3391-025

Accept

Revision ID: H

Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: 4 & Dwg D3391 Rev: 4 2-Deburr	0.00 0.00				1	0		
130  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				1	0		
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				1	0		

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Item ID: D3391-025

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Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

AK 2 MB 09-11-19

160



CNC Bend 1

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

Form as per Dwg D3391 Using Bend Prog 3391025

DP/11

9-11-23

170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

2) 501/130

h = 4.06'
L = 4.5'

40

Work Order ID 52797

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Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Item Name: Aft Tube Assembly

Stop



Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								

11/9/12/11

DP
9-12-1

Work Order ID 52797

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Item ID: D3391-025

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Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27502/12/01						
200 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	11/9/12/1		
210 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	DP			9-12-1			

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Item ID: D3391-025

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Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>0112417</u> exp. date: <u>10/12/30</u> cure time 12hrs as per QSI0015								
230		0.00							
	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
240		0.00							
	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>10:55</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>11:25</u>								

Work Order ID 52797

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Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

=> HP 09/12/08



260



HandFinish

Hand Finishing

HandFinishing

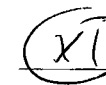
Memo

- ✓ 1-Install inserts as per Dwg D3391
- ✓ 2-Install Aft Cap as per Dwg D3391
- ✓ A/R Sikaflex-241/-291 M112345
- Sikaflex expiry date: 10/08

0.00

0.00

=> HP 09/12/08



270



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> HP 09/12/08



Work Order ID 52797

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Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

M 09/12/08

(X1)

0

Packaging

290

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/09

PL 0912-9

Picklist Print

October 14, 2009 10:46:37 AM

Page 1

Work Order ID: 52797

Parent Item: D3391-025RevH

Parent Item Name: Aft Tube Assembly

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D6014-090RevA Manufactured No



ALUMINUM EXTRUSION

100 Each 21.0000 1.0000



0.11 09-10-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

21

42768

21

D3670-4-200RevA Manufactured No



SPACER

230 Each 163.0000 4.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

163

46106

4

47122

32

48198

42

48269

85

4

10/12/11

Picklist Print

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Work Order ID: 52797



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly


Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC  Aft Cap		Manufactured	No			270	Each	55.0000	1.0000			

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	55	
20208	0	
43801	1	
46327	6	
48109	48	

xl Hl 09/12/08

D3537-1RevC



Manufactured No

270 Each 199.0000 1.0000



Wearpad

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	162	
51678	162	
Main Warehouse		
ST	35	
51918	35	

xl Hl 09/12/08

Picklist Print

October 14, 2009 10:46:37 AM

Work Order ID: 52797



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-7RevC

Manufactured

No

270

Each

23.0000

1.0000



Wearpad

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

23

45408

9

46346

14

X1 H 09/12/08

D3553-1RevA

Manufactured

No

270

Each

18.0000

1.0000



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

18

33868

18

X1 H 04/12/08

D3553-3RevA

Manufactured

No

270

Each

7.0000

1.0000



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

7

47206

7

X1 H 09/12/08

Picklist Print

October 14, 2009 10:46:37 AM

Work Order ID: 52797



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			270	Each	2,060.000	2.0000			
Phenolic Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1560	
39275	19	
42329	19	
47628	522	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

v2 41 09/12/08

ALS4-1032-130

Purchased

No

260

Each

5,373.000

14.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5373	
110511	5373	

M1111529

x14 41 09/12/08

Picklist Print

October 14, 2009 10:46:37 AM

Work Order ID: 52797



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			270	Each	7,911.000	12.0000			

Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

7911

107441

16

110768

7895

AN3C4A

Purchased

No

270

Each

2,216.000 6.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

2216

112082

14

112314

40

112720

162

112724

500

112794

1000

112829

500

X12 H 09/12/08

X6 H 09/12/08

Picklist Print

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October 14, 2009 10:46:37 AM

Work Order ID: 52797



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A 		Purchased	No			270	Each	718.0000	4.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	718	
111424	8	
111707	69	
112314	11	
112489	100	
112641	500	
112720	30	

x4 51 09/12/08

AN960C10L



washer

Purchased

No

270

Each

4,772.000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4672	
112116	1009	
112612	3663	

1112935

x10 41 09/12/08

DART AEROSPACE LTD	Work Order: 52797
Description: Float Skidtube (412)	Part Number: D3391-3
Inspection Dwg: D3391 Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

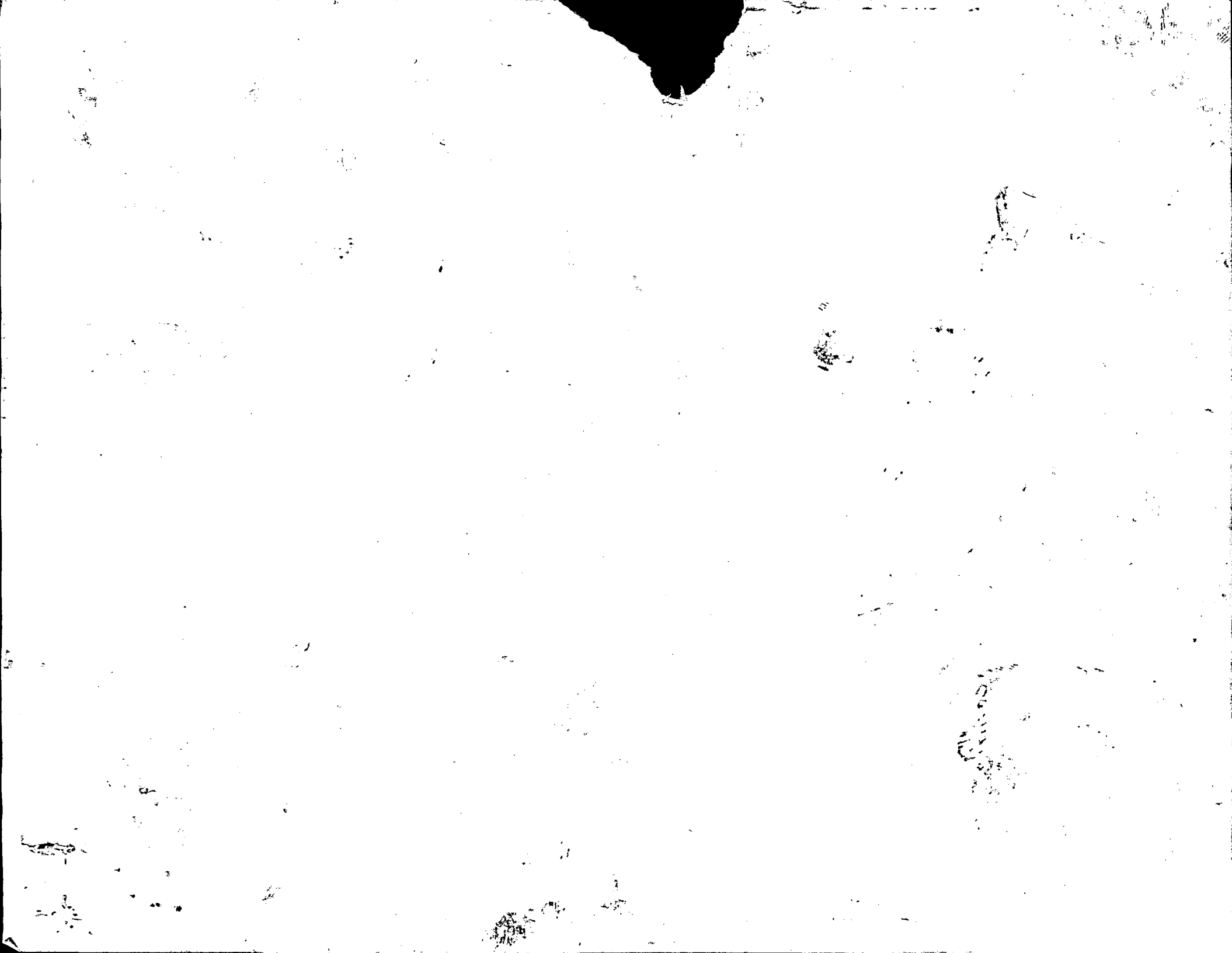
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	/			
3.500	+/-0.010	3.502	/			
88.93	+/-0.030	88.945	/			
44.995	+/-0.030	44.985	/			
Ø3.200	+/-0.010	3.201	/			
88.93	+/-0.030	88.945	/			
Ø3.750	+/-0.010	3.751	/			
30° x 160" chamfer	+/-0.010	30° x 160"	/			

Measured by: a.m	Date: 09.10.28
Audited by: f	Date: 09/10/28

HAAS Section						
1.526	+0.000/-0.030	1.520	✓			
0.200	+/-0.010					
7.500	+/-0.010	7.499	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.302	✓			
0.200	+/-0.010	202	✓			
3.520	+/-0.010	3.518	✓			
0.687	+0.010/-0.000	-690	✓			
R0.062	+/-0.010	0.062	✓			
Ø0.484	+0.005/-0.001	485	✓			

Measured by: JL	Date: 09/11/16
Audited by: [Signature]	Date: 09/11/18

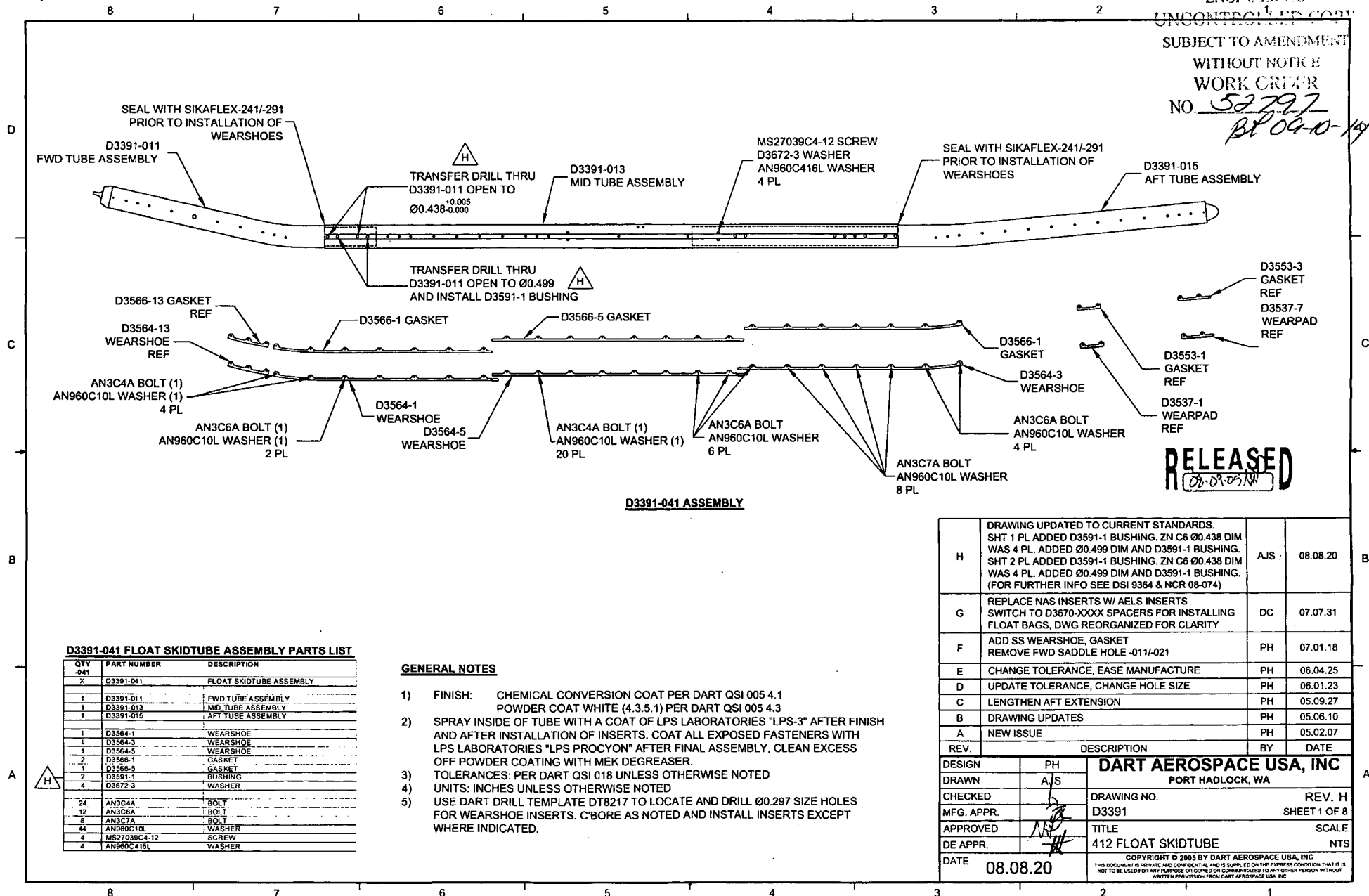
Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	[Signature]



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 52797
BP 09-0-14



D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

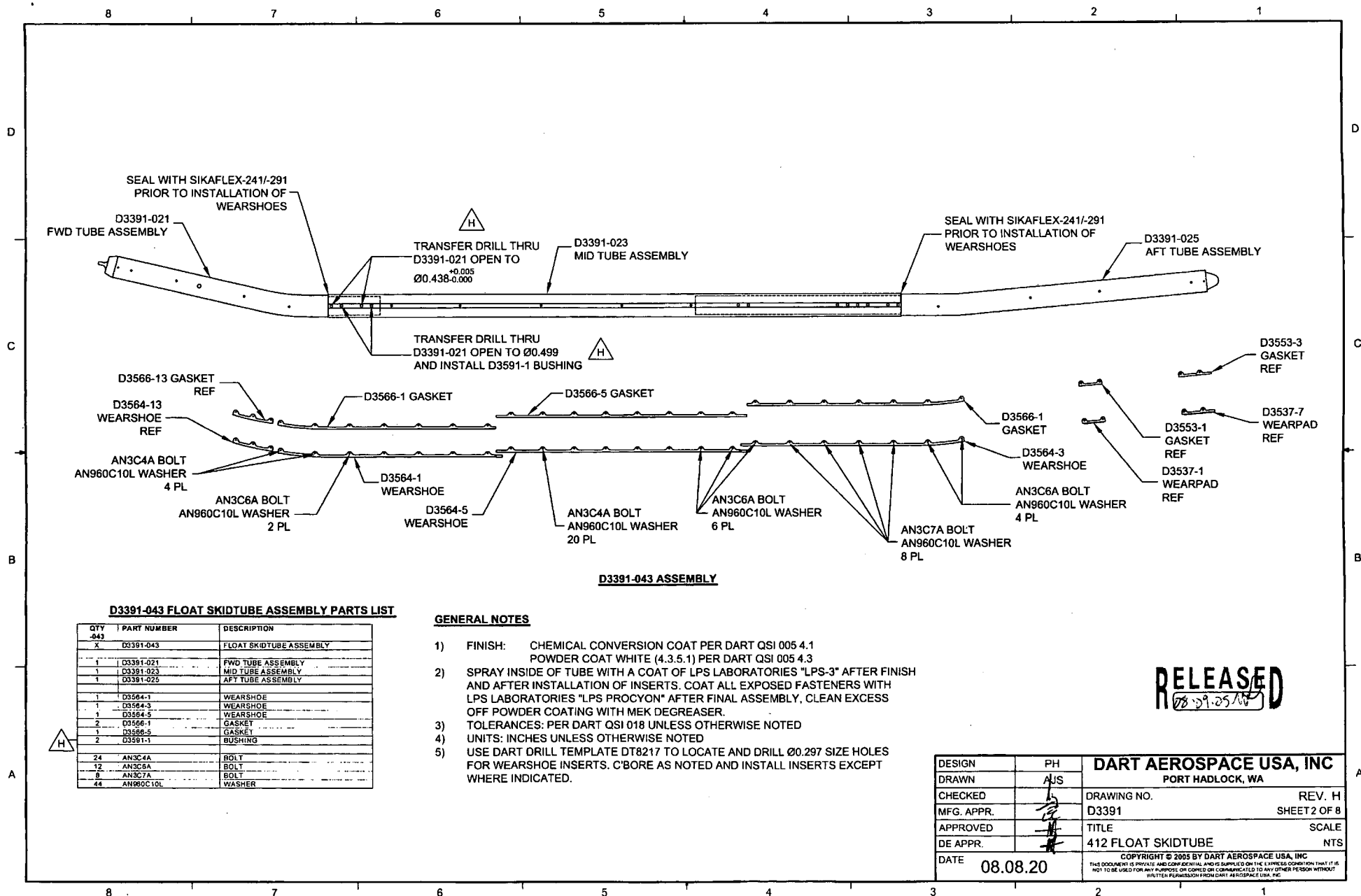
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

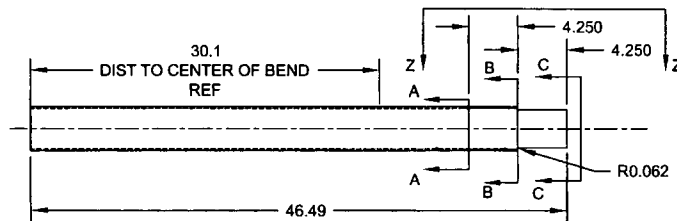
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

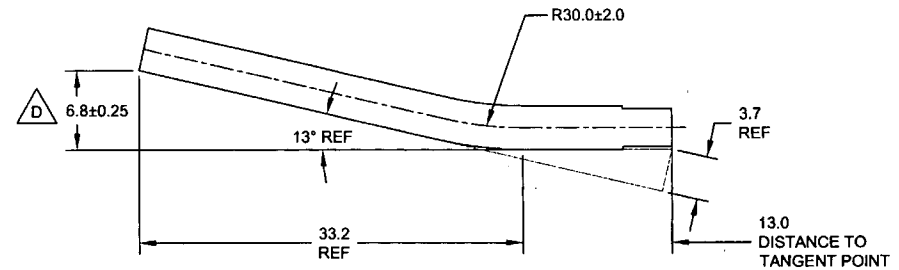
W/O 52797



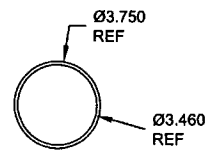
W/052797



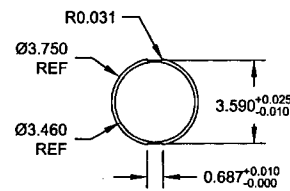
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



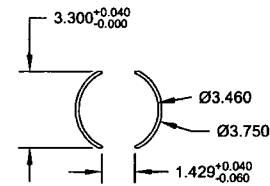
D3391-011/-021 BENDING DETAIL
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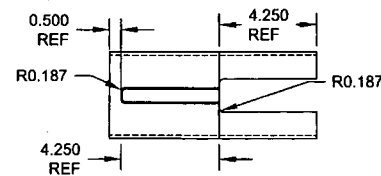
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SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

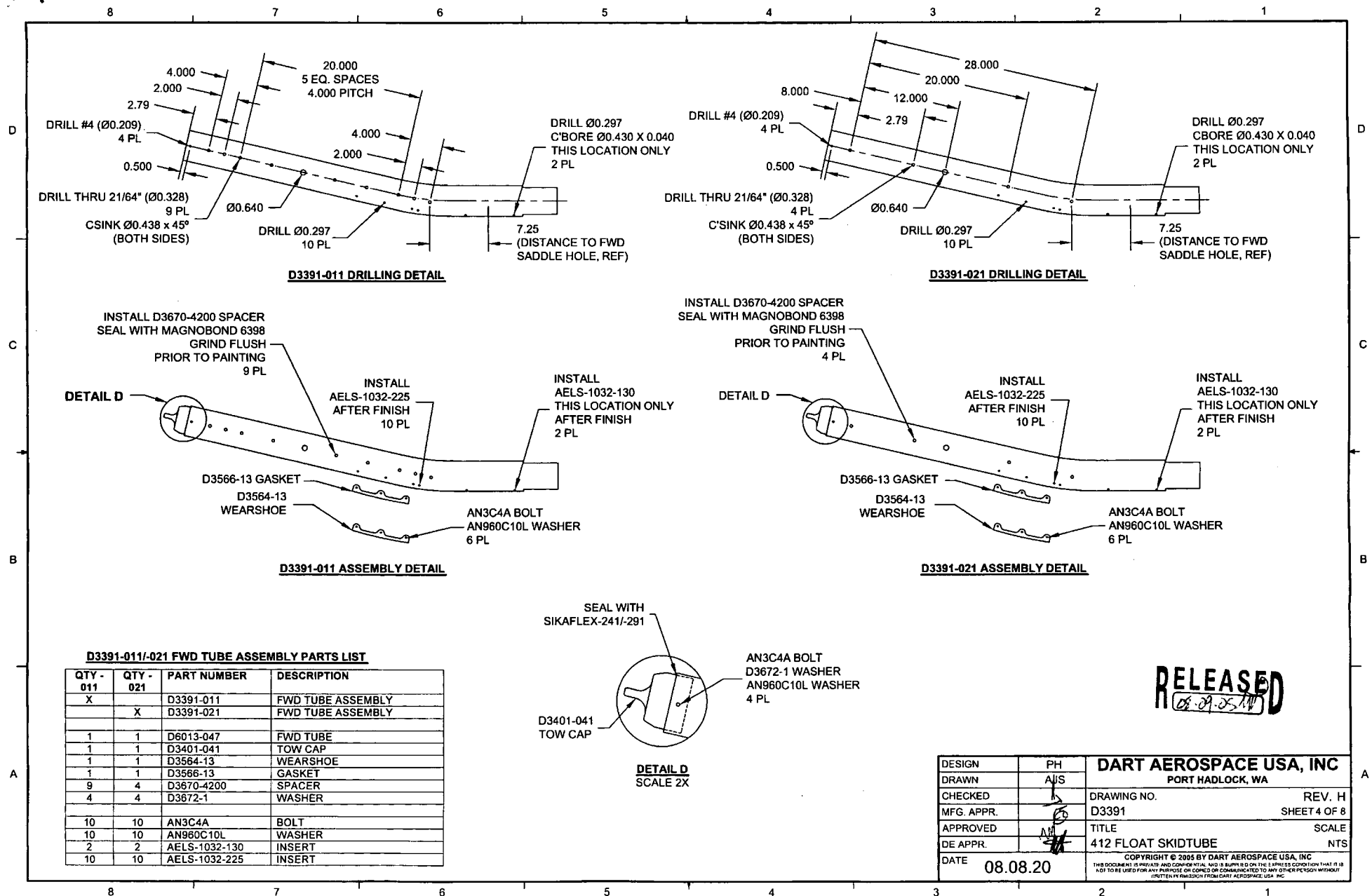


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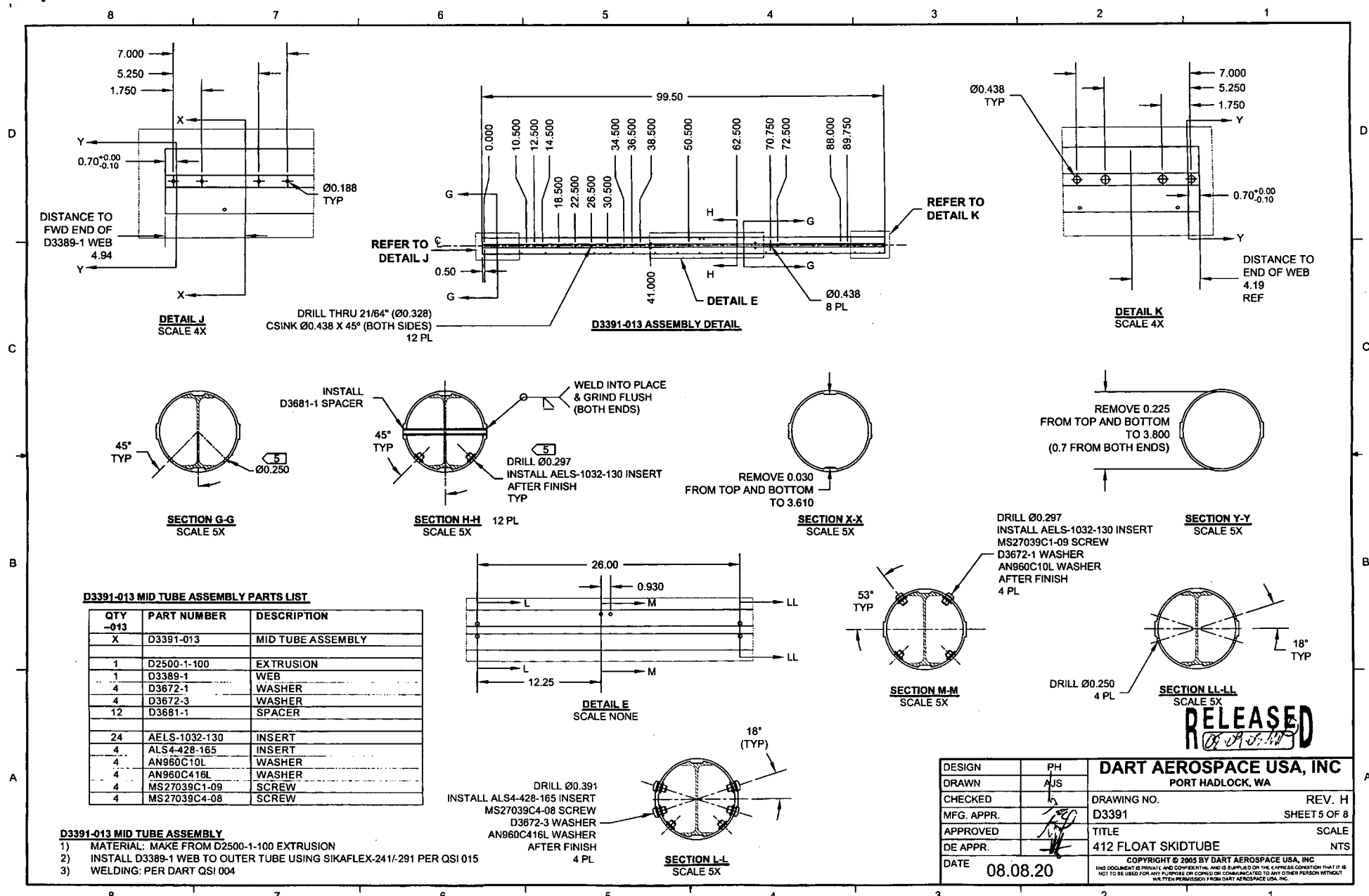
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w/o 52797



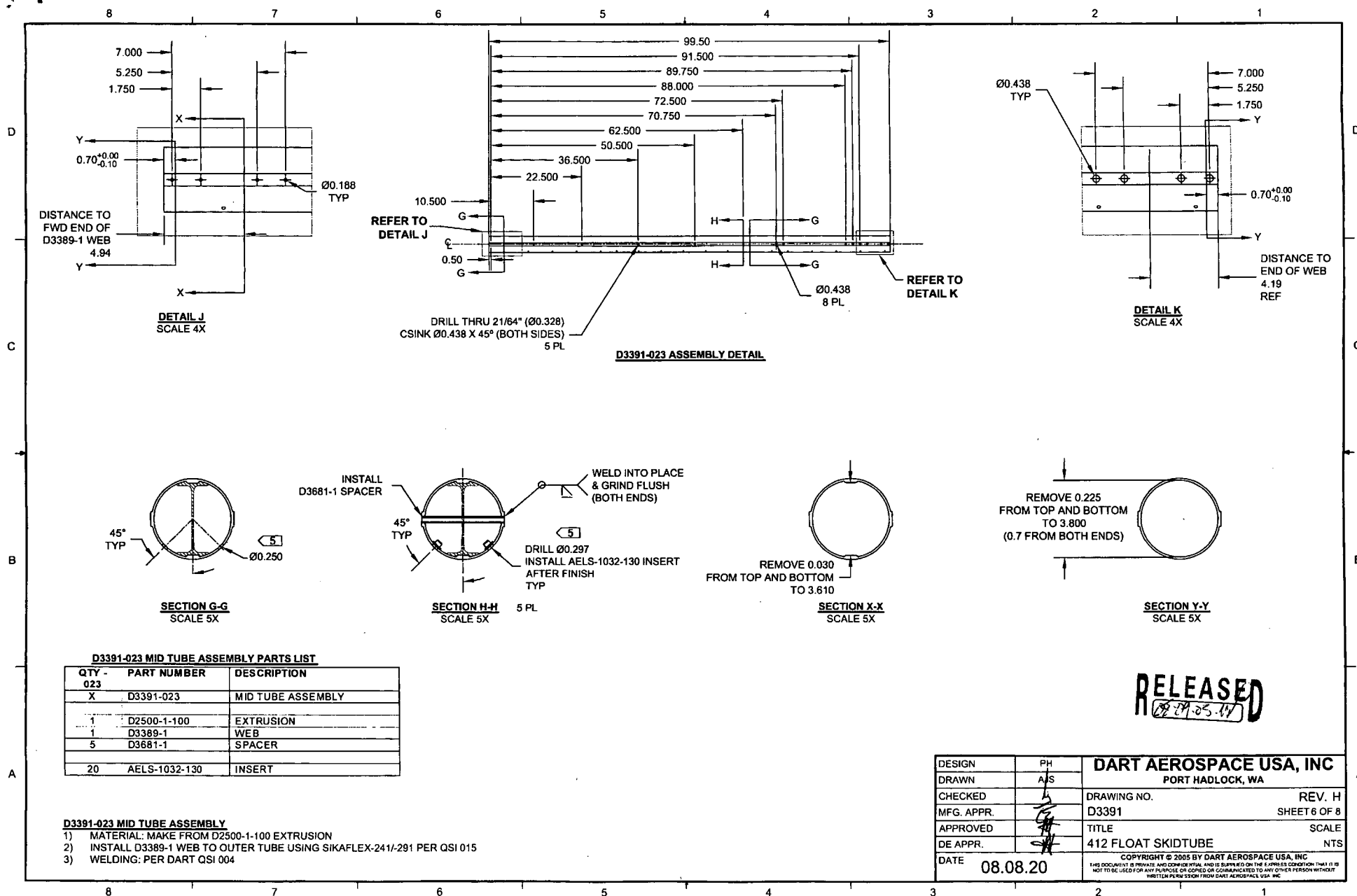
W/O 52797



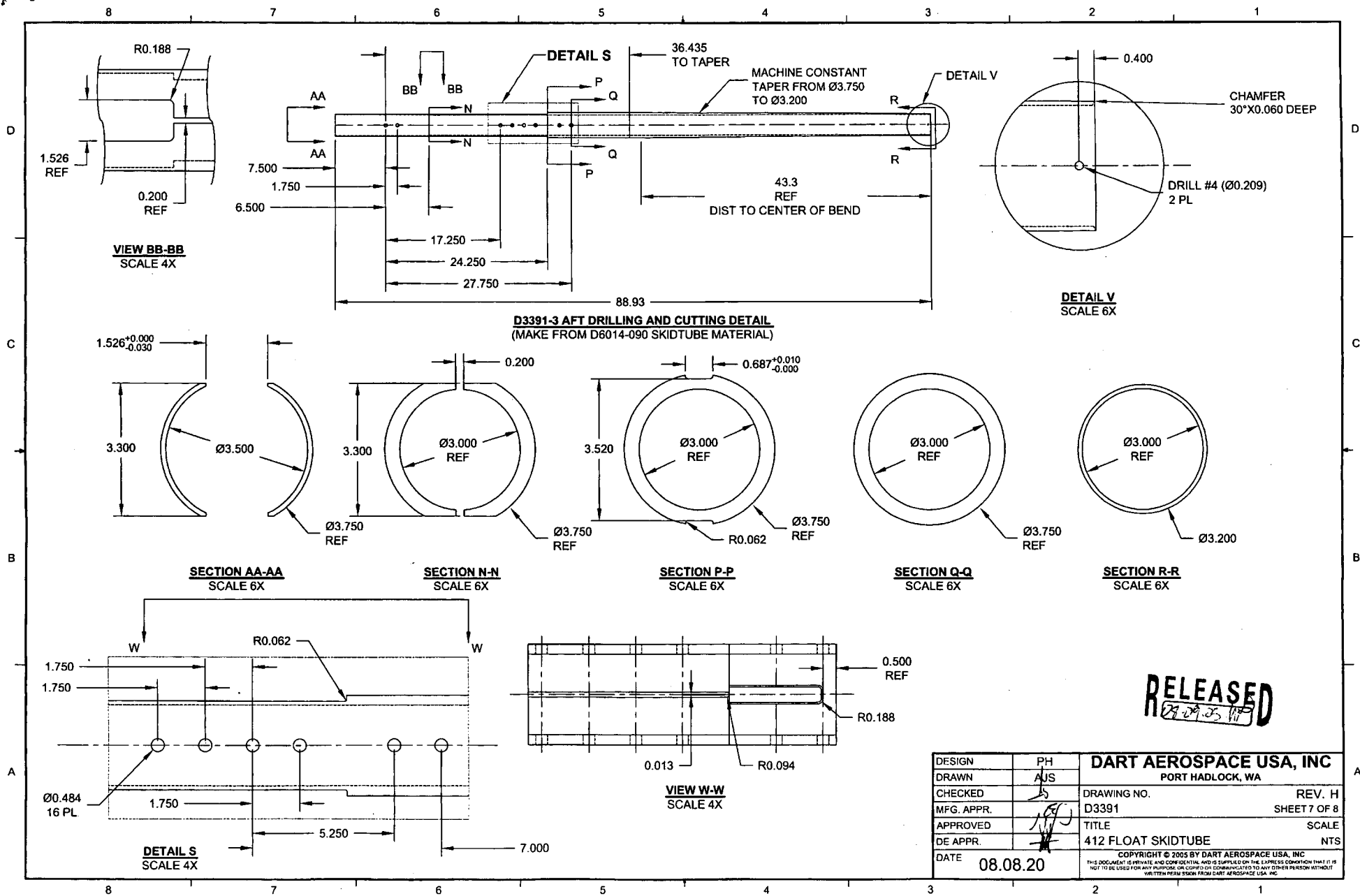
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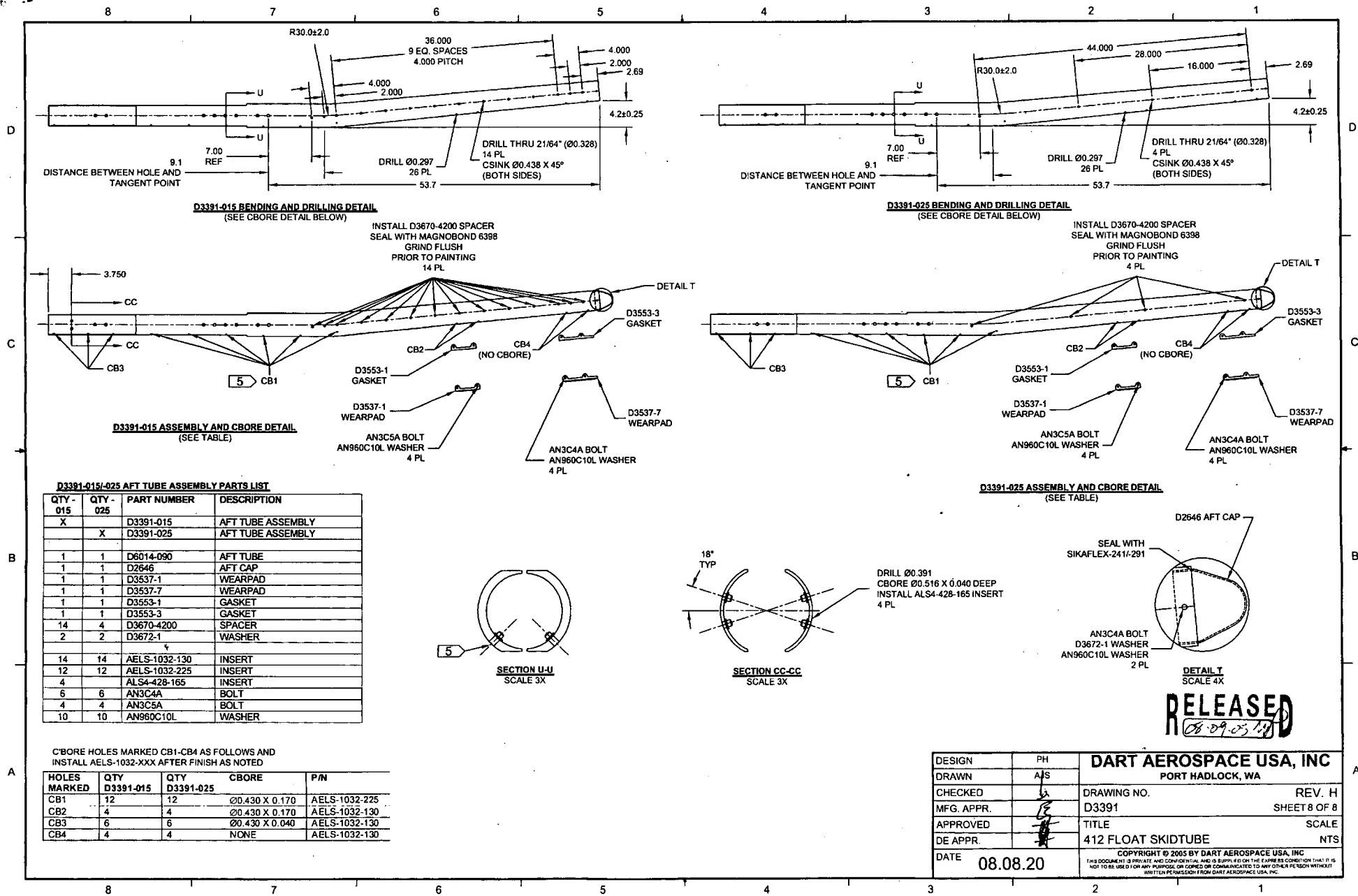
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